

Ship 04/06

Dart Aerospace Ltd.

Date: Tuesday, 03/06/2008 2:00:34 PM  
User: Linda Lacelle

## Process Sheet

split  
SRB 08/06/04

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MIRROR ARM
Job Number	: 39681-2		
Estimate Number	: 10335		
P.O. Number	:	Part Number	: D2010104
This Issue	: 03/06/2008 S.O. No. :	Drawing Number	: D2010 PRELIM
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: PRELIM
Previous Run	: 39431	Material	:
Written By	:	Due Date	: 04/06/2008
Checked & Approved By	:	Qty:	20 Um: Each
Comment	: Est A 04.02.17 New issue KJ/JLM Est Rev:B 08-05-27 as per ECN1195P DD verified by:EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0500W049	304 RD Tube .500 x .049W
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Comment: Qty.: 1.5750 f(s)/Unit Total: 15.7500 f(s)  
Material: 304/316 SS tubing 0.500" Dia. x 0.049" wall  
(M304TR0500W049) Batch No: M108 215

SRB 08/06/04 20

2.0	BRAKE NC	NC BRAKE
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Comment: BRAKE NC  
Punch per Dwg. D2010-104 and Spec Control Dwg D2727  
Identify as D2010-104

SRB 08/06/04 20

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
1- Bend as per Dwg D2010 using bending Jig D2010-104T2  
2- Deburr ends

EC 08/06/04 (20)

4.0	D2057	Plug
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)  
Plug  
batch: 2057 39661

FF 08-06-09 (20)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1- flare before installing plug as per dwg D2010

FF 08-06-09 (20)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Tuesday, 03/06/2008 2:00:34 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR ARM

Job Number: 39681

Part Number: D2010104

Job Number:



Seq. #:

Machine Or Operation:

Description :

2- Install D2057 plug as per Dwg D2010

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/06/10 (20)

7.0

POWDER COATING

POWDER COATING



M102316



(20X)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

8:30

OVEN TEMPERATURE:

320 °F

FINISH TIME:

9:00

m.h. 08/06/10

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FD 08/06/10 (20)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 228

P 8/6/10 (20)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/10

Job Completion



U 08-06-10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

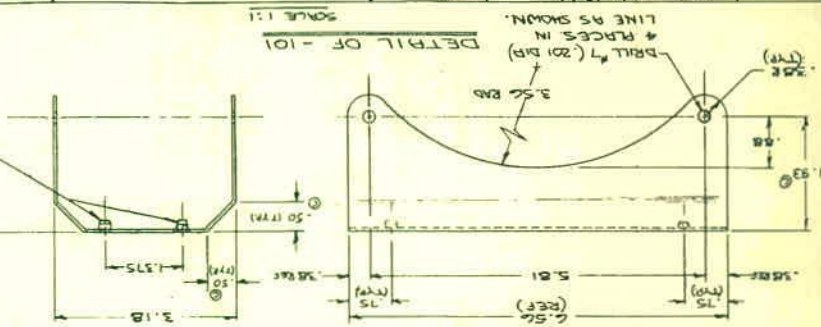
NOTE: Date & initial all entries



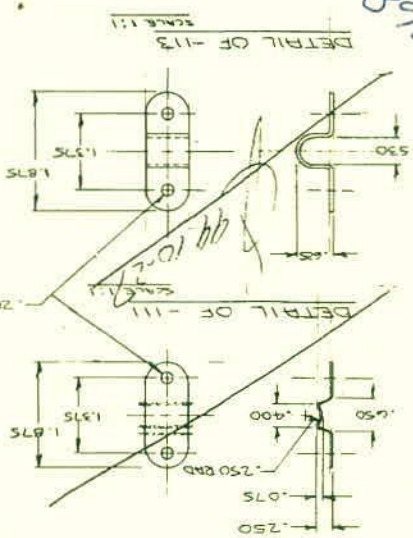
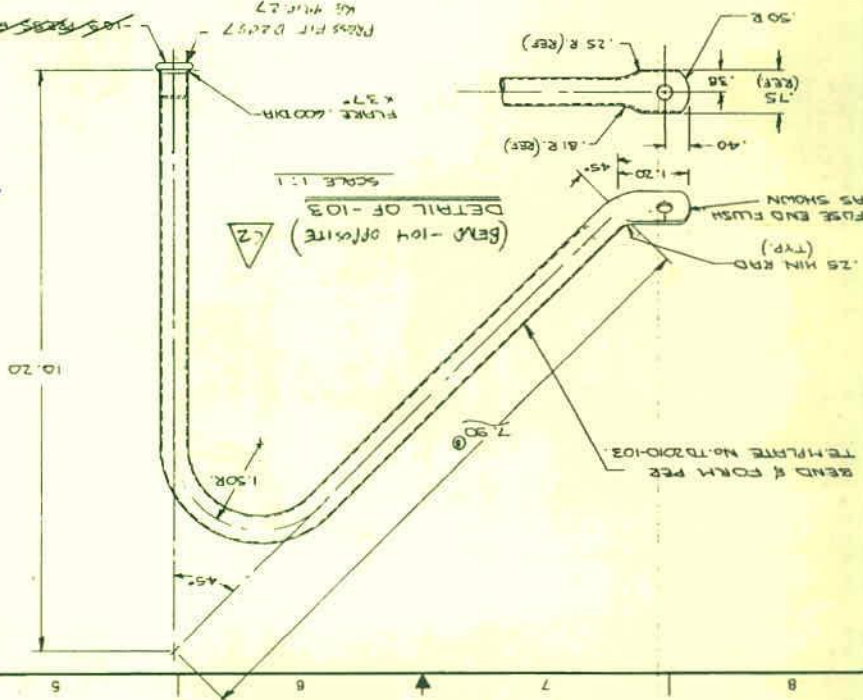
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ITEM NO.	DESCRIPTION	MATERIAL	QTY	UNIT	PRICE	TOTAL
1	100-100	100-100	100	100	100	100
2	100-100	100-100	100	100	100	100
3	100-100	100-100	100	100	100	100
4	100-100	100-100	100	100	100	100
5	100-100	100-100	100	100	100	100
6	100-100	100-100	100	100	100	100
7	100-100	100-100	100	100	100	100
8	100-100	100-100	100	100	100	100
9	100-100	100-100	100	100	100	100
10	100-100	100-100	100	100	100	100
11	100-100	100-100	100	100	100	100
12	100-100	100-100	100	100	100	100
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14	100-100	100-100	100	100	100	100
15	100-100	100-100	100	100	100	100
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18	100-100	100-100	100	100	100	100
19	100-100	100-100	100	100	100	100
20	100-100	100-100	100	100	100	100
21	100-100	100-100	100	100	100	100
22	100-100	100-100	100	100	100	100
23	100-100	100-100	100	100	100	100
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26	100-100	100-100	100	100	100	100
27	100-100	100-100	100	100	100	100
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99	100-100	100-100	100	100	100	100
100	100-100	100-100	100	100	100	100

1. BEND RADIUS FOR 2024-T3  
0.63 THICK IS .188  
2. PAINT -101 WHITE BLACK  
3. THE 304 STAINLESS STEEL MAY  
BE SUBSTITUTED WITH TYPED  
303 OR 316  
4. 2024-T3 MAY BE SUBSTITUTED  
WITH 2024-T3 CLAD (20-4-23/5)  
FINISH: FINEST CONT BLACK SHADED  
5. (43.1) PER PART QD 06-4.3  
6. FE-0022-EF (Q174)  
INSTALL PER PERM INSTALLATION  
INSTRUCTIONS.



GENERAL NOTES:



W/o 39681

RELEASED 04-02-03

UNDER REVIEW  
08-05-87  
-103/-104 TO  
HAVE 0-045 TO WALL

Scale 4:1  
 Supplied by D2057 m B  
 JE 01.03.19 152A1229

